

Work Order ID 73279

Page 1

Thursday, September 08, 2011 9:07:37 AM

Item ID: D2333-103

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing Assembly

Start Date: 8/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2333

Rev B

105

0.00



Purchasing

Memo

14883

0.00

ISSUE PO
MAKE PER DRWG D2333 REV B
SUPPLIER: CINTUBE1109.08

106

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

ENSURE MAT'L CERTS ATTACHED

0.00

Rec'd 9/21 (1)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Sulab

1109.08

Quality Control

Work Order ID 73279

Page 2

Thursday, September 08, 2011 9:07:37 AM

Item ID: D2333-103

Accept



Setup Start



Revision ID:

Stop



Item Name: Tubing Assembly

Start Date: 8/30/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 9/2/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Identify as per dwg & Stock Location: ST

0.00



Packaging

Memo

0.00

Packaging

U 11.09.21

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

U 11/9/21 JD

U 11.09.21

Picklist Print

Page 1

Thursday, September 08, 2011 9:45:06 AM

Work Order ID: 73279

Parent Item: D2333-103

Parent Item Name: Tubing Assembly





Start Date: 8/30/2011

Required Date: 9/2/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C 00.12.05 Re-format EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN818-16J  Nut		Purchased	No			100	Each	8.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST332				8					
					107715			8			2		
D2333-103P  Tubing Assembly		Purchased	No				Each	0.0000		1			
M2650-16  Firesleeve-crinkle		Purchased	No			100	f	15.5000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST420A				15.5			3.9		
					106071			15.5					
M304TR1.000W.049  304 RD Tube 1.00 x .049W		Purchased	No				f	19.9863		1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT018				19.986315					
					111457			12.66			3.9		
					117598			7.326315					

Picklist Print

Page 2

Thursday, September 08, 2011 9:45:06 AM

Work Order ID: 73279

Parent Item: D2333-103

Parent Item Name: Tubing Assembly

Start Date: 8/30/2011

Required Date: 9/2/2011

Start Qty: 1.00

Required Qty: 1.00

MS20819-16J

Purchased

No

100

Each

4.0000

2

2



Sleeve



SB 11/09/08

Location

Loc Qty

Loc Code

ST299

4

107649

4

2

Thursday, September 08, 2011 9:45:07 AM

Shop Packet Print

Page 2



DESIGN B WILLIAMS	DRAWN BY B WILLIAMS	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED CA	DRAWING NO. D2333	REV. B SHEET 1 OF 4
DATE 96:02:27		TITLE TUBING ASSEMBLIES SCALE	
B	96:02:27	ADDITIONAL DRAWINGS ADDED	

-107	-105	-103	-101	Part No.	Description
X	X	X	X	D2333	B205 HEATER TUBES
	2	2	2	AN818-16J	NUT
	2	2	2	MS20819-16J	SLEEVE
1	1	1	1	FIRESLEEVE 2650-16	INSULATION SLEEVE
2				AN818-16D	NUT
2				MS20819-16D	SLEEVE

MATERIAL: 1" OD X 0.049 WALL 304/316 STAINLESS STEEL

NOTES:

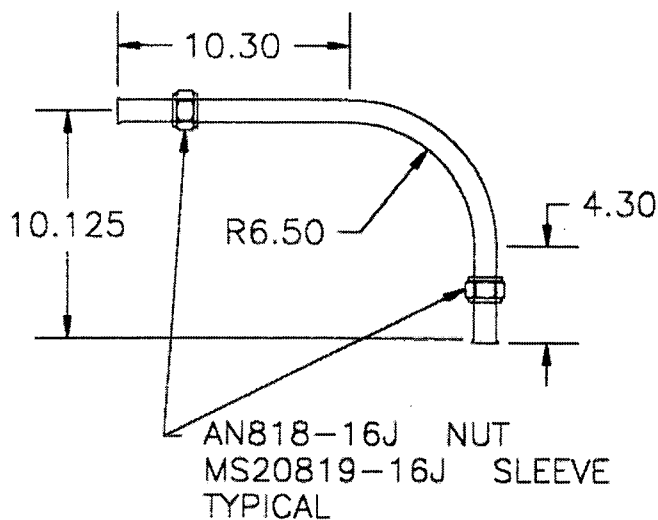
1. BEND PER TEMPLATES IDENTIFIED PER TUBE PART NUMBER WITH 'T' PREFIX
2. FLARE TO MATE MS33514 FLARED FITTINGS
3. INSTALL 2650 FIRESLEEVE (STRATOFLEX) OVER ALL TUBE ASSEMBLIES

72279

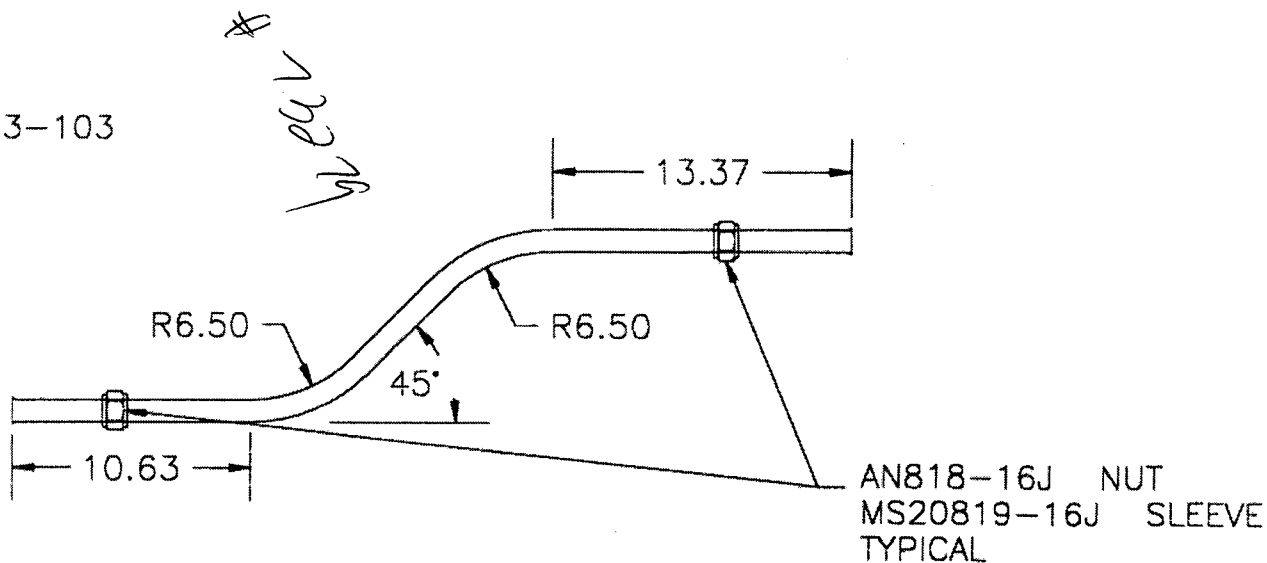


DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BWS	APPROVED [Signature]	D2333-101	SHEET 2 OF 4
DATE 96:02:26	TITLE HEATER TUBES		SCALE 1:1

D2333-101



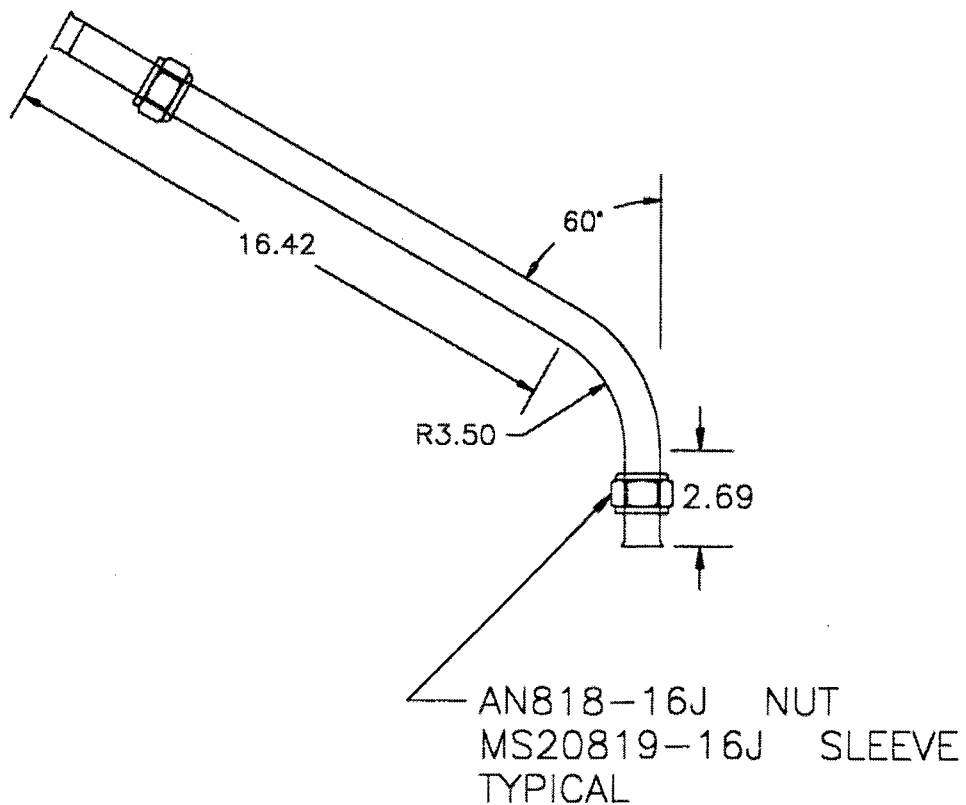
D2333-103



INSTALL FIRESLEEVE ON ALL TUBING



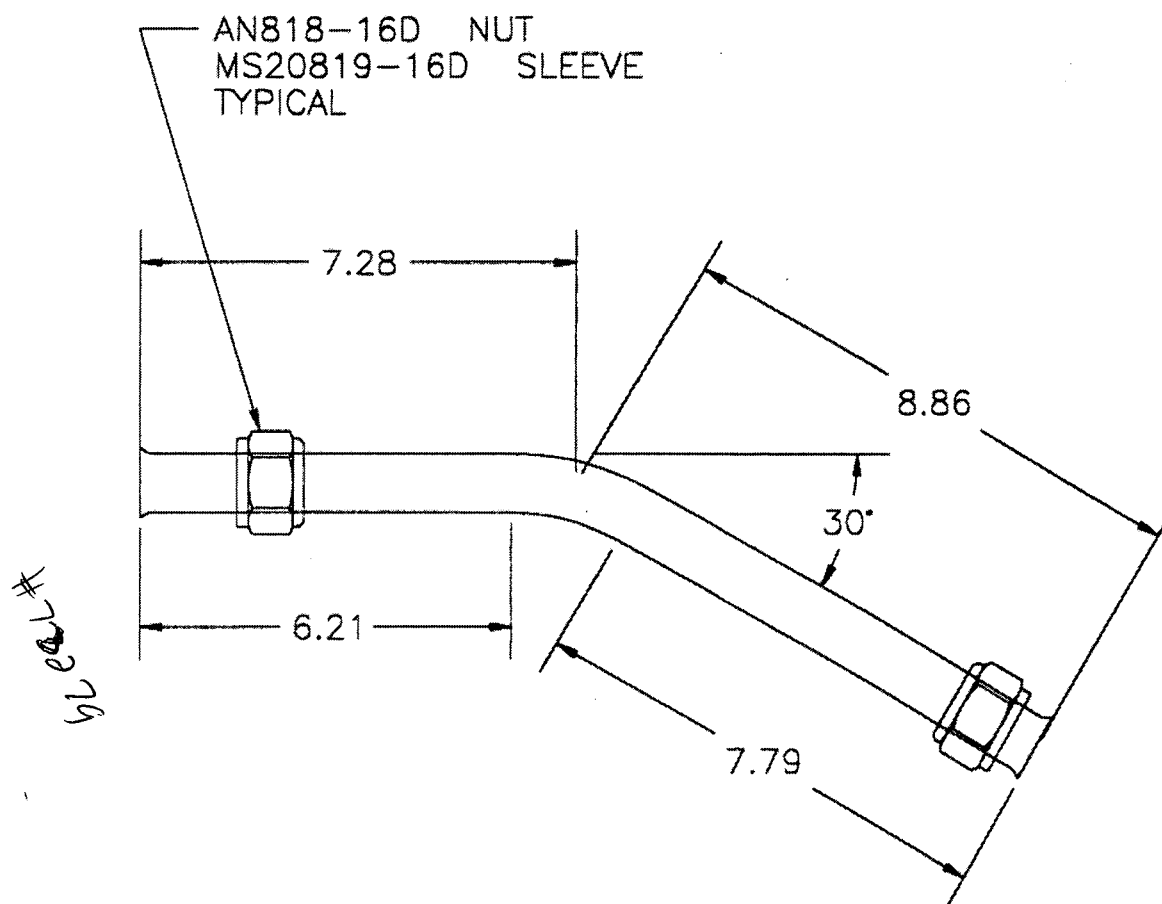
DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BW	APPROVED Ø	D2333-105	SHEET 3 OF 4
DATE		TITLE	SCALE
96:02:26		HEATER TUBING	1:1



INSTALL FIRESLEEVE ON ALL TUBING



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	B WILLIAMS	DRAWING NO.	REV. B
CHECKED BJS	APPROVED [Signature]	D2333-107	SHEET 4 OF 4
DATE	TITLE		SCALE
96:02:26	HEATER TUBING		1:1





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO14853

Purchase Order Date 9/8/2011

PO Print Date 9/8/2011

Page Number 1 of 1

Order From :

VC-CIN001

CINTUBE LTEE
333 ST-JOSEPH BLVD
LACHINE, QC H8S 2K9
CA

Contact Name

Vendor Phone

514 634 3592

Vendor Fax

514 636 3336

Vendor Account Nbr

Buyer

Linda Lacelle

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D2333-103P	Tubing Assembly	9/15/2011 Yes	1.00 Each	FedEx Overnight	\$320.0000	\$320.00

Special Inst: MAKE PER DRWG D2333 REV.B
C OF C REQUIRED
ALL PARTS SUPPLIED BY DART
3.9' X M304TR1.000W.049 B117598
2 X AN818-16J B107715
3.9 X M2650-16 B106071
2 X MS21819-16J B107649

2	D2333-105P	Tubing Assembly	9/15/2011 Yes	1.00 Each	FedEx Overnight	\$320.0000	\$320.00
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Special Inst: MAKE PER DRWG D2333 REV.B
C OF C REQUIRED
ALL PARTS SUPPLIED BY DART
2.1' X M304TR1.000W.049 B117598
2 X AN818-16J B107715
2.1 X M2650-16 B106071
2 X MS21819-16J B107649

PO Total:

\$640.00

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Change Nbr: 1

Change Date: 9/8/2011

CINTRAGE DE PRÉCISION, DE TUBES, TUYAUX, CORNIÈRES, POUTRES,
PROFILÉS EN "U", ET SERPENTINS.
MANUFACTURIER DE GÉNÉRATRICE À VAPEUR, ÉLÉMENT CHAUFFANT,
RÉCUPÉRATEUR DE CHALEUR, ÉCONOMISEUR ETC.
PRECISION BENDING OF TUBES, PIPES, ANGLES, BEAMS, CHANNELS, COILS.
MANUFACTURERS OF STEAM GENERATORS, THERMAL FLUID HEATERS,
WASTE HEAT RECOVERY UNITS, ECONOMIZERS.

333 BOUL. ST-JOSEPH, LACHINE, QUÉBEC H8S 2K9
TÉLÉPHONE: (514) 364-6426 FAX NO: (514) 636-3336

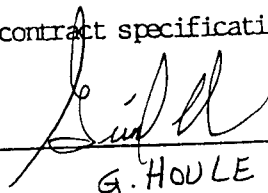
LETTRE DE CONFORMITÉ - LETTER OF COMPLIANCE

Client/Customer DART AEROSPACE LTD Date: SEPT. 20 / 2011
N° de commande du client/Customer order No: PO14853
Notre n° de feuille de route/Our order No: 116009
Notre n° de dessin/Our drawing No: —
Description/Customer drawing No: D2333-103 AND D2333-105
Nom de la pièce/Part Name: HEATER TUBES
ONE PIÉCE OF EACH

La présente est pour certifier que le matériel ci-haut mentionné se conforme aux exigences contractuelles de qualité et/ou de la confirmation de la commande, qu'il a été produit, inspecté et testé selon les spécifications standards applicables de notre programme de contrôle de la qualité, du contrat et du(des) dessin(s).

This is to certify that the material covered by this document conforms to the quality requirements of the purchase order or contract, that the material has been produced, verified and tested according to applicable standard specifications listed in our quality control procedures, contract specifications and/or drawing(s).

Signé par/Signed by:



G. HOULE pour B. OVERBURY

Directeur des services techniques/Technical Services Director



Pour la Compagnie Cintube Ltée/On behalf of Cintube Ltd.